

Page 1

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION <div style="display: flex; justify-content: space-around;"> <div>Rework <input type="checkbox"/></div> <div>Skid-tube <input type="checkbox"/></div> <div>Crosstube <input type="checkbox"/></div> <div>Water Jet <input type="checkbox"/></div> <div>Engineering <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Scrap <input type="checkbox"/></div> <div>Machining <input type="checkbox"/></div> <div>Small Fab <input type="checkbox"/></div> <div>Prod. Eng. Coord. <input type="checkbox"/></div> <div>Quality <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Use-as-is <input type="checkbox"/></div> <div>Thermoforming <input type="checkbox"/></div> <div>Finishing <input type="checkbox"/></div> <div>Rec/Store/Packaging <input type="checkbox"/></div> <div>Other <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Work Order Update <input type="checkbox"/></div> <div>Large Fab <input type="checkbox"/></div> <div>Composite <input type="checkbox"/></div> <div>Supplier <input type="checkbox"/></div> </div>		AGAINST DEPARTMENT/PROCESS					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
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Work Order ID 88466

88466

Page 2

August-02-12 10:35:31 AM

Item ID: D2435 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw, 206
 Start Date: 7/27/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 12-9-25					
151 *151* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	POP	88454					22 12/9/25 SD
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/9/24 JD MK 12-09-25

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Picklist Print

August-02-12 10:35:30 AM

Page 1

Work Order ID: 88466

Parent Item: D2435

Parent Item Name: Bearpaw, 206

Start Date: 7/27/12

Required Date: 8/17/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	105.8100	3.2	6.4 6.5			Im28x

Location	Loc Qty	Loc Code
----------	---------	----------

MAT018	82.7	
120972	1	
121346	27.1	
121954	12.8	
122286	14.3	
122575	27.5	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

122722

122722

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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DART AEROSPACE LTD		Work Order:	88466
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053	✓		VERN	PHO-01
B	5.500	+/-0.030	5.502	✓		"	"
C	0.200	+/-0.030	0.193	✓		MIC	PHO-09
D	R0.250	+/-0.030	.250	✓		R.G.	
E	0.250	+/-0.010	.245	✓		VERN	PHO-01
F	0.625	+/-0.030	.623	✓		"	"
G	0.25 x 45°	+/-0.030	.250	✓		"	"
H	0.375	+/-0.010	.383	✓		"	"
I	19.000	+/-0.030	19.00	✓		M TAPE	PHO-11
J	0.950	+0.030/-0.010	.951	✓		VERN	PHO-01
K	Ø0.260	+0.005/-0.000	.260	✓		"	"
L	Ø0.930	+/-0.030	.931	✓		"	"
M	0.30	+0.030/-0.000	.313	✓		MIC	PHO-09
N	0.375	+/-0.030	.375	✓		VERN	PHO-01
O	7.375	+/-0.030	7.375	✓		VERN	CNC-02
P	4.250	+/-0.010	4.250	✓		"	PHO-01
Q	2.000	+/-0.030	2.016	✓		"	"
R	9.000	+/-0.010	9.000	✓		"	CNC-02
S	15.750	+/-0.030	15.750	✓		M TAPE	PHO-11

Measured by: <u>JD</u>	Audited by: <u>SL</u>	Prototype Approval:	N/A
Date: <u>12/09/24</u>	Date: <u>12-9-25</u>	Date:	

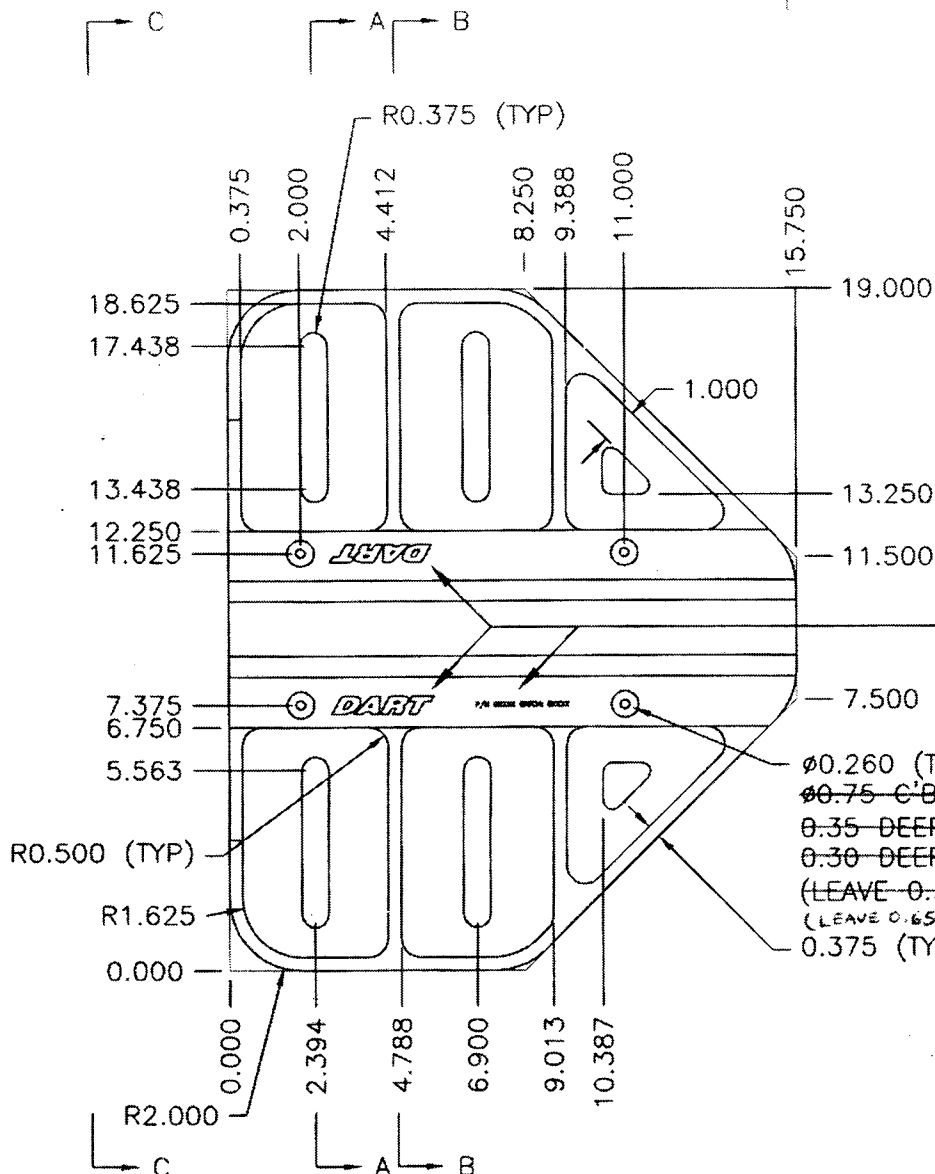
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <u>FF</u>	<u>FF</u>

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMIT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
88466 ML5
12/08/13



RELEASED
18 DEC 17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



Ø0.260 (TYP) Ø0.93 C'BORE
Ø0.75 C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)



9143	

EFFECTIVE DEOS

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2435
DATE	TITLE	SHEET 1 OF 2
98.05.19	BEARPAW	SCALE
A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

